

SLUT

Date: Tuesday, 4/4/2006 1:27:44 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
Job Number : 26502
Estimate Number : 11479
P.O. Number : N/A
This Issue : 4/4/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : N/A
Written By : See comment below
Checked & Approved By : 06.04.04
Comment : Est. A 03.02.28 New issue KJ/RF

Part Number : D31451
Drawing Number : D3145 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 4/24/2006 Qty: 10⁹ Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X02000 6061-T6 Bar 2.0" x 2.0"



Comment: Qty.: 0.4025 f(s)/Unit Total : 4.0247 f(s)
6061-T6 Bar 2.0" x 2.0"
Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8)
M6061T6B2.000x2.000)
Batch: M17124

mk 06/05/05 10

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

mk 06/05/05 10

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine per Folio FA318 and Dwg D3145
Deburr and Tumble

mk 06/05/05 9

4.0A Q66 QC2 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J.L 06/05/05 (9)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1





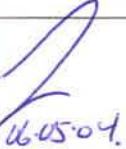


Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

a.m 06-05-11 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/04	3	1 piece scrap engraving too deep, and the wall too thin 1 piece scrap, too mark in the slot. .015 deep. could cause cracking. And will have to thin if marks removed. Marks caused from clamping too tight.	 GAF42	Scrap: destroy, replace.	 06/05/05	 06-05-10	 GAF42	 06-05-04.

NOTE: Date & initial all entries

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Part Number: D31451

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-16

(9)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/5/17

(9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

monique

6/5/17

(9)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/05/18

Job Completion



W 06/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26502
Description: Bracket		Part Number:	D3145-1
Inspection Dwg: D3145	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.240	+/-0.010	0.243	✓			
0.180	+/-0.010	0.179	✓			
R0.250	+/-0.010	R0.250	✓			
1.250	+/-0.010	1.250	✓			
1.960	+/-0.010	1.962	✓			
Ø0.221 x 0.351	+/-0.010	Ø0.226 x 0.352	✓			
0.108	+/-0.010	0.110	✓			
0.125	+/-0.010	0.125	✓			
1.636	+/-0.010	1.640	✓			
R0.188	+/-0.010	R0.188	✓			
0.125	+/-0.010	0.127	✓			
95°	+/-0.5°	95°	✓			
R0.387	+/-0.010	R0.387	✓			
0.766	+/-0.010	0.766	✓			
0.250	+/-0.010	0.251	✓			
1.370	+/-0.010	1.375	✓			
0.760	+/-0.010	0.760	✓			
4.303	+/-0.010	4.313	✓			
0.219	+/-0.010	0.220	✓			

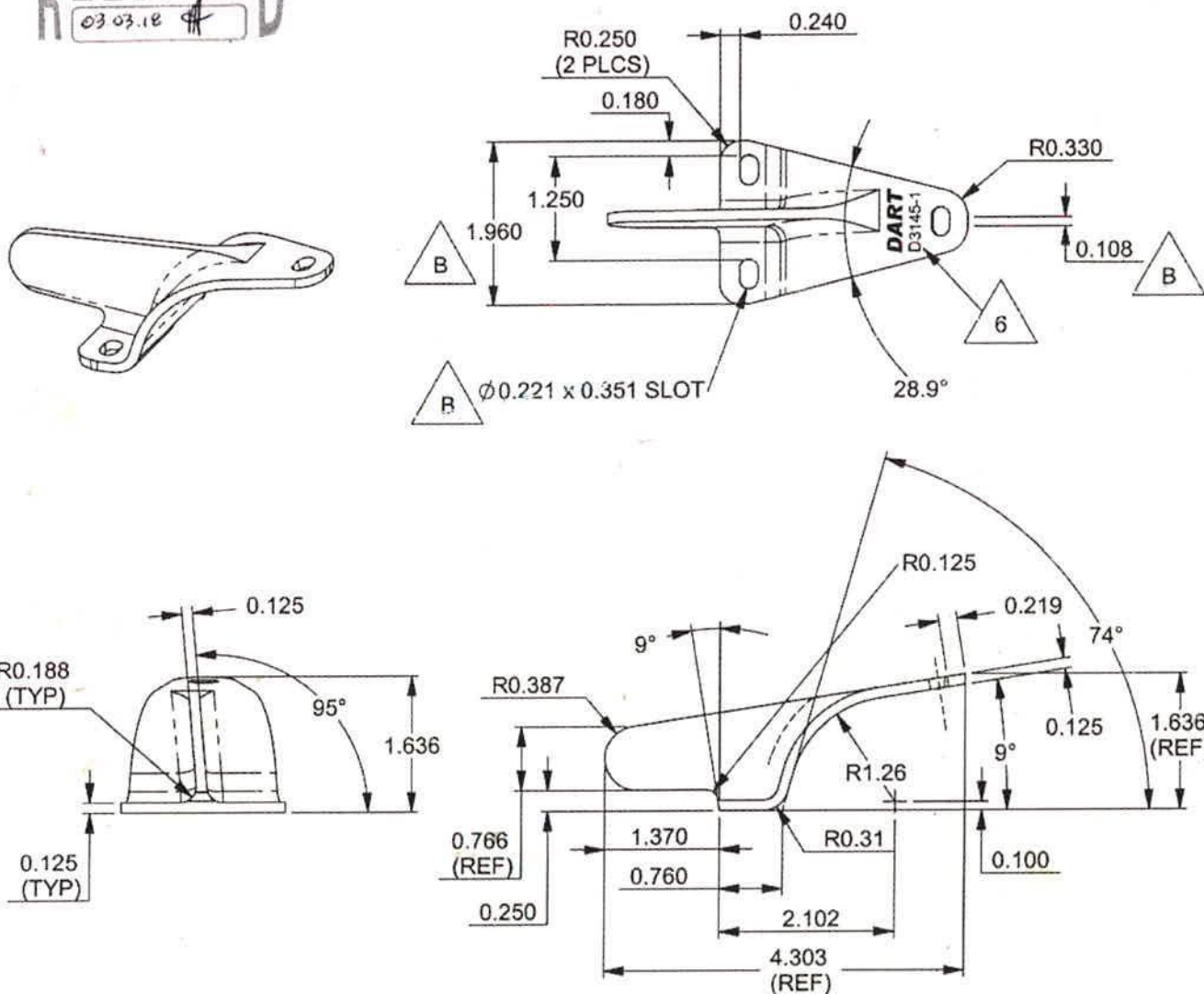
Measured by: <i>JML</i>	Audited by: <i>J.L</i>	Prototype Approval:	N/A
Date: 06/05/04	Date: 06/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>RH</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06	TITLE BRACKET	SCALE 1:2	
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

RELEASED
03 03 18



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26502

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